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D2278
Job Sheet 178548



Part No: D2278

Job Qty: 12 ea

Part Name: Step Leg



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP Rev:A New Issue 05-11-07 JLM IPP Rev:B Now 6061-T6 06-06-23 JLM IPP Rev C New flat pattern 08.01.11 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		6/20/18	0.00	0.00	Start Up Waterjet		SL 18/06/18
100	Waterjet	12 pcs		6/20/18	0.01	1.35	Waterjet1		SL 18/06/18
110	QC	12 pcs		6/20/18	0.00	0.00	QC2		SL 18/06/18
120	QC	12 pcs		6/20/18	0.00	0.00	QC8		36
130	HandFinish	12 pcs		6/20/18	0.00	0.32	HandFinish1		SA 18-06-21
140	QC	12 pcs		6/20/18	0.00	0.00	QC7		38
150	Packaging	12 pcs		6/20/18	0.00	0.00	Packaging3		SPR-7-3
160	QC21-SA	12 Ea		6/20/18	0.00	0.00	QC21		21 JUL 04 2018

Part Op 100 - 1-Cut as per Dwg D2278
Descriptions: 150 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	11.7780 sf (.9815 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	12	183	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Leg	0.354Inches $\pm$ 0.010	0.364 0.344	0,354	
2	Leg	0.354Inches $\pm$ 0.010	0.364 0.344	0,355	
3	Leg	16.460Inches $\pm$ 0.030	16.490 16.430	16,463	
4	Leg	0.128Inches + 0.005 - 0.000	0.133 0.128	0,178	
5	Leg	0.354Inches $\pm$ 0.030	0.384 0.324	0,354 Radius	
6	Leg	2.000Inches $\pm$ 0.030	2.030	2,000	

Work Order update only

[illegible]

			1.970	
7	Leg	4.740Inches ± 0.030	4.770 4.710	4,747
8	Leg	8.460Inches ± 0.030	8.490 8.430	8,466
9	Leg	0.213Inches ± 0.010	0.223 0.203	0,213
10	Leg	0.750Inches ± 0.010	0.760 0.740	0,750
11	Leg	0.080Inches ± 0.010	0.090 0.070	thick 0,080

Plex 6/1/18 1:44 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	
			Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							